

Work Order ID 51705

August 28, 2009 6:51:41 AM



Page 1

Item ID: D2356-042

Accept



Setup Start



Revision ID: E

Stop



Item Name: Low Float Step Ass'y RH

Start Date: 8/31/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 4.00 *5.00*



Customer:

Reference:

Approvals: Process Plan:

Date: *09-09-24* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | Memo | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
|----------|--------------|---|------|------|------|------|------|------|------|
| D2356 | Rev E | | | | | | | | |
| 100 | | Large Fab | | | | | | | |
| | | Memo | 0.00 | | | | | | |
| | | Cut D2356-2 from D2244 extrusion as per Dwg D2356 using cutting table setup DT 8185-L <input type="checkbox"/> Drill D2365-2 as per Dwg D2356 using Jig DT 8230 <input type="checkbox"/> Bend per Dwg D2356 using Bend Program D2356.2D and Folio FT0124 <input type="checkbox"/> Deburr and bevel ends for welding | | | | | | | |
| 110 | | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | |
| | | Memo | 0.00 | | | | | | |
| | | <i>→ Satisfied</i> | | | | | | | |
| | | <i>Satisfied</i> | | | | | | | |
| 120 | | Large Fab | 0.00 | | | | | | |
| | | Memo | 0.00 | | | | | | |
| | | Weld end cap and bracket as per Dwg D2356 using Jig DT <input type="checkbox"/> Grind end cap weld flush Remove all sharp edges from weld on bracket <input type="checkbox"/> See sample DT 8245 | | | | | | | |
| | | <i>→ 09.09.13</i> | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2356-042 PAR #: 09-031 Fault Category: Prod - Large Fab NCR: Yes No DQA: Date: 09.11.03

Resolution: Service Disposition: Service QA: N/C Closed: Date: 05.11.18

| NCR: S1705 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|--|----------------------------------|---|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09.09.01 | 100 | Qty 10 steps are scrap. Steps kept breaking in the bending at the most aft hole location. This was caused because there was 8 holes drilled in the step, instead of 6 per dwg. Steps | 09/09/02 09/09/02 09/09/02 | Paint the 2 (4) holes aft section of the DT8230 drill Jig red, and rivet an I.D plate on it to advise the fabricator to not use for D2356-041/042 | 09.09.03 | S 09/09/03 | 09/09/02 09/09/02 | 09/09/02 |
| | | were inspected prior to bending by QC. The dwg is w/o calls up the correct drilling, BUT the DT8230 Jig also has 8 holes that are scribed for the appropriate steps. | 09/09/02 | steps, and I.D the appropriate steps, per dwg. See PAR 09-031 - Qty 10 are scrap: to be destroyed. Replace B/N: D38023 | 09.09.03 | S 09/09/03 | 09/09/02 | 09/09/02 |
| | | R.C: Lack of Attention to drawing details. | 09/09/02 | Re-do bend program to be able to bend the steps correctly. Retrain QC & Fab to ensure to verify parts → dwg. | 09.09.03 | S 09/09/03 | 09/09/02 | 09/09/02 |

NOTE: Date & initial all entries

Work Order ID 51705

Page 2

August 28, 2009 6:51:41 AM

Item ID: D2356-042

Revision ID: E

Item Name: Low Float Step Ass'y RH

Start Date: 8/31/09 Start Qty: 4.00

Accept



Setup Start



Stop



Required Date: 9/11/09 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

AD

09.10.13



140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ 809.10.13

0.00



150



Large Fab

Large Fab

0.00

0.00

H 09.10.14

5

f

Large Fab

Memo

Rivet as per Dwg D2356

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2356-042 PAR #: N/A Fault Category: Large fab NCR: Yes No DQA: SL Date: 09-11-03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: J Date: 08-11-03

| NCR: 51705 A | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------------|------|--|-----------------------------|--|----------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 10/03 | 100 | one step over bent during Bending Process - first step. QC Process / when re-adjusting the bend program from previous NCR. | <u>SL</u> 10/10/03 | Scrap and Destroy no reverse extra were cut. | MS 09-09-03 07/09/03 | <u>S</u> 07/09/03 | <u>SL</u> 10/10/03 | <u>S</u> 10/10/03 |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 51705

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Page 3

Item ID: D2356-042

Accept



Setup Start



Revision ID: E

Item Name: Low Float Step Ass'y RH

Stop



Start Date: 8/31/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
Code

Accept
Qty

X5

Reject
Qty

4

Reject
Number

Insp.
Stamp

170



HandFinish

Hand Finishing

Memo

Weld as per drawing End cap
Chemical Conversion Coat per QSI005 4.1

0.00

09-10-13

180



Powdercoat

Powder Coating

Memo

0.00

QC9 correct weld

PD 09.10.14

QC5 insure work to current spec → Solvithy

45 4

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 11/22/00

09-10-16

Memo

0.00

START TIME: 10:00 OVEN TEMPERATURE:

320° FINISH TIME: 10:30

5

PtC 7

Pressure Wash

X5

Touchup/stocking

X5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

D550-591-124

Part No: D2356-042 PAR #: N/A Fault Category: Finisher NCR: Yes No DQA: 18 Date: 09-11-03
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: ✓ Date: 09-11-18

| | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|-----------------------------|--|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09-10-19 | 180 | SAWNED DOWN 320 Grit TOUCH UP ALCORINE PER QSI 005 | | | | | | |
| 09-10-19 | 180 | RECOAT PER QSI 005 | | | | | | |
| 09-10-19 | 180 | SCRATCH from material | | SAWNED DOWN 320 Grit TOUCH UP ALCORINE AND RECOAT WHITE PER QSI 005 | 09-10-19 | | | |
| 09-10-19 | 180 | RL Process. (not seen at inspection) | | START 12:00 OVER 300° FINISH 12:35 | 09-10-19 | S 09-10-19 | R 09-10-19 | S 09-10-19 |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 51705

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Item ID: D2356-042

Accept



Setup Start



Revision ID: E

Stop



Item Name: Low Float Step Ass'y RH

Start Date: 8/31/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Wing C02(L)

Memo BATCH: m112106

0.00

MP 08/10/10

X5

200



QC3- Inspect Part Finish

0.00

JF 08/10/10

X5 P

QC

Quality Control

210



Identify as per dwg & Stock Location:

0.00

PP

L 8/12/10

Packaging

Packaging

Memo

0.00

S1890

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 51705

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August 28, 2009 6:51:41 AM

Item ID: D2356-042

Accept



Setup Start



Revision ID: E

Stop



Item Name: Low Float Step Ass'y RH

Start Date: 8/31/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

220



QC

**Operation
Description**

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

09/10/23

Quality Control

Memo

0.00

BLOG 10-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 2

August 28, 2009 6:51:40 AM

Work Order ID: 51705



Parent Item: D2356-042RevE



Parent Item Name: Low Float Step Ass'y RH

Start Date: 8/31/09

Required Date: 9/11/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|------------------|--------|
| D2643-1RevB1 | | Manufactured | No | | | 150 | Each | 39.0000 | 4.0000 | | <i>✓ 09-09-1</i> | |

Lo Skid Step Assy LH

| | | | | <u>Warehouse</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
|--------------|--|--------------|----|------------------|--|----------------|-----------------|---------|--------|--|----------|--|
| | | | | <u>Location</u> | | | | | | | | |
| | | | | Premier | | <i>✓</i> | | | | | | |
| | | | | Mezz | | 39 | | | | | | |
| | | | | 16928 | | 39 | | | | | | |
| D2643-2RevB1 | | Manufactured | No | | | 150 | Each | 39.0000 | 4.0000 | | <i>5</i> | |

Lo Skid Step Assy LH

| | | | | <u>Warehouse</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
|-------------|--|--------------|----|------------------|--|----------------|-----------------|---------|--------|--|----------|--|
| | | | | <u>Location</u> | | | | | | | | |
| | | | | Premier | | | | | | | | |
| | | | | Mezz | | 39 | | | | | | |
| | | | | 16929 | | 14 | | | | | | |
| | | | | 9725 | | 25 | | | | | | |
| D2849-4RevA | | Manufactured | No | | | 150 | Each | 28.0000 | 4.0000 | | <i>5</i> | |

End Bracket

| | | | | <u>Warehouse</u> | | <u>Loc Qty</u> | <u>Loc Code</u> |
|--|--|--|--|------------------|----------------|----------------|-----------------|
| | | | | <u>Location</u> | | | |
| | | | | Premier | <i>51958=4</i> | | |
| | | | | Mezz | <i>B9404=1</i> | 28 | |
| | | | | 27873 | | 21 | |
| | | | | 9423 | | 7 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | | |
|---------------------|-----------------------|--|--------------|--------------|
| DESIGN KE | DRAWN BY <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>#</i> | APPROVED <i>PH</i> | DRAWING NO. D2356 | REV. E | SHEET 1 OF 2 |
| DATE 05.11.14 | | TITLE LOW FLOAT STEP ASSEMBLY | SCALE NTS | |
| A | 95.02.16 | NEW ISSUE | | |
| B | 97.05.22 | END CAPS CHANGED | | |
| C | 97.07.23 | ADDED BUSHING AND FACING INFO | | |
| D | 98.10.13 | CHANGED TO BEND, D2849 REPLACES D2358 & D2359, INCORP. DEO 9084 | | |
| E | 05.11.14 | UPDATE FINISHING NOTE | | |

*W0 S1705*D2356 LOW FLOAT STEP ASSEMBLY PARTS LIST

| Part No. | Description | QTY -041 | QTY -042 |
|--------------|------------------------------|-------------|-------------|
| D2356-041 | Low Float Step Assembly (LH) | X | |
| D2356-042 | Low Float Step Assembly (RH) | | X |
| D2244-52.7 | STEP EXTRUSION* | 1 | 1 |
| D2643-1 | STEP LEG ASSEMBLY | 1 | 1 |
| D2643-2 | STEP LEG ASSEMBLY | 1 | 1 |
| D2673-34 | STEP END PLATE | 1 | 1 |
| D2849-1 | END BRACKET | 1 | |
| D2849-2 | END BRACKET | | 1 |
| MS20600AD4W3 | RIVETS | 12 | 12 |

*cut per drawing

RELEASED
05-11-28

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

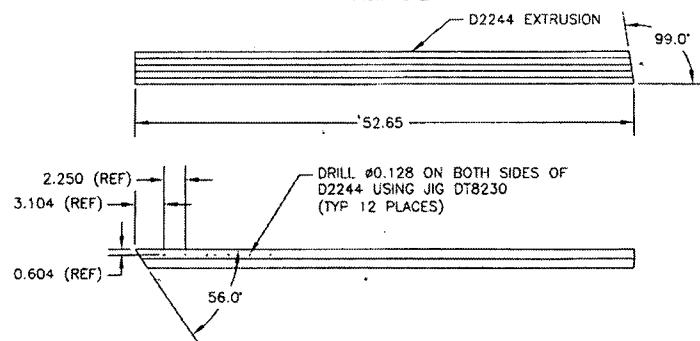
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

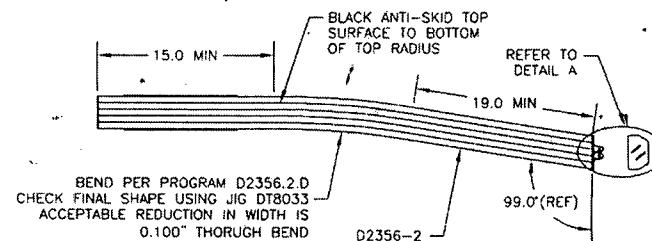
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

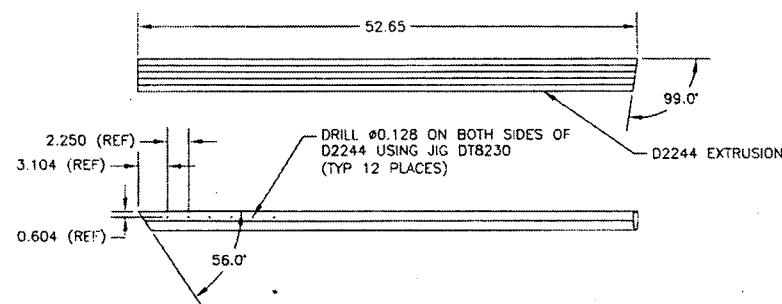
D2356-2 CUTTING/DRILLING DETAIL
RIGHT STEP



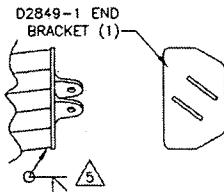
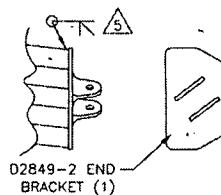
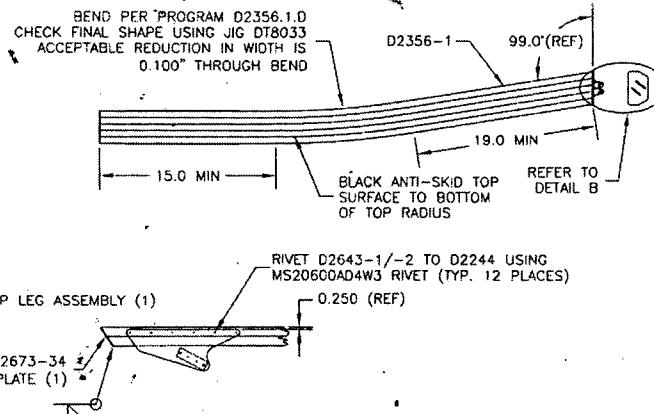
D2356-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2356-1 CUTTING/DRILLING DETAIL
LEFT STEP



D2356-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



D2643-2 STEP LEG ASSEMBLY (1)

D2643-1 STEP LEG ASSEMBLY (1)

D2673-34
END PLATE (1)

WFO 51705

RELEASED
CS-11-28

DETAIL A
SCALE: 1:4

GENERAL NOTES

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.4
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 CHAMFER D2244 EXTRUSION 0.075" x 45° BEFORE WELDING D2849-1 OR D2849-2 IN PLACE. DO NOT GRIND FLUSH

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DART AEROSPACE LTD.

DESIGN
BY
BW

CHECKED


APPROVED


DRAWN BY
04

DRAWING NO.
D2356

DART

DART AEROSPACE LTD.
MANSFIELD, ONTARIO, CANADA

REV. E

SHEET 2 OF 2

DATE
05.11.14

TITLE
LOW FLOAT STEP ASSEMBLY

SCALE
1:12

W/O:

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries